



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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PRIORITY

D2891-1

Job Sheet 202850



Part No: D2891-1

Job Qty: 5 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/19

Job Tracking No:

Due Date: 11/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified: DD IPP Rev:E 11.08.04 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	5 pcs	11/22/19		1.00	4.10	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	5 pcs	11/22/19		0.00	0.00	QC 2 - 1		M/B-19-11-30
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S236352



Part: D2891 - 1

Job No: 202850

Serial No/Batch: S236352

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 11/30/19

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120 QC 8	5 pcs	11/22/19	0.00 0.00	QC 2 - 8	A- 19-11-30
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	27ml 19/12/01
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Crosstubes - 2 - B4B	5 pcs	11/22/19	0.00 0.24	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	DAS
				Crosstubes - 4 - B4B	41 DEC 01 2019
140 QC 3	5 pcs	11/22/19	0.00 0.00	QC 3 - 10	9-89
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	40
				QC 3 - 19	DEC 02 2019 9-89
				QC 3 - 43	

170 Packaging 3-1 - Stock - B4B 5 pcs	11/22/19	0.00 0.00	QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	DAG
			Packaging 3 - 23 - B4B	41 DEC 02 2019
			Packaging 3 - 24 - B4B	9-89
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	DAS
180 QC 21 - SA 5 pcs	11/22/19	0.00 0.00	QC 21 - SA - 21	21
			QC 21 - SA - 70	9-89 DEC 02 2019
			QC 21 - SA - 53	

Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 5206997 exp 8/21
 140 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: LG050 LOCATION : LG052
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	2.5000 pcs (.5 ea)	100-HAAS 4 Axis	5200832 (X4)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK076	3	16	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches $\pm$ 0.000	0.000 0.188		
2	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240		
3	2.250 Support	0.115Inches $\pm$ 0.000	0.000 0.115		
4	2.250 Support	0.040Inches $\pm$ 0.000	0.000 0.040		
5	2.250 Support	0.010Inches $\pm$ 0.000	0.000 0.010		
6	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240		
7	2.250 Support	0.290Inches $\pm$ 0.000	0.000 0.290		
8	2.250 Support	0.115Inches $\pm$ 0.000	0.000 0.115		
9	2.250 Support	0.454Inches $\pm$ 0.000	0.000 0.454		
10	2.250 Support	2.779Inches $\pm$ 0.000	0.000 2.779		
11	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240		
12	2.250 Support	1.002Inches $\pm$ 0.000	0.000 1.002		
13	2.250 Support	0.053Inches $\pm$ 0.000	0.000 0.053		
14	2.250 Support	0.257Inches $\pm$ 0.000	0.000 0.257		
15	2.250 Support	1.663Inches $\pm$ 0.000	0.000 1.663		
16	2.250 Support	0.053Inches $\pm$ 0.000	0.000 0.053		
17	2.250 Support	0.022Inches $\pm$ 0.000	0.000 0.022		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				

DART AEROSPACE LTD		Work Order: 202850
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.188	.188	0.189	0.189	0.189
AB	0.240	0.260		.245	.247	0.249	0.247	0.242
AC	0.115	0.150		.125	.125	0.125	0.125	0.125
AD	0.040	0.060		.051	.051	0.054	0.052	0.054
AE	0.010	0.020		.010	.010	0.010	0.010	0.010
AF	0.240	0.260		R.250	R.250	0.250	0.250	0.250
AG	0.290	0.310		.300	.300	0.300	0.300	0.300
AH	0.115	0.150		.138	.138	0.138	0.138	0.138
AI	0.454	0.474		.463	.461	0.463	0.463	0.461
AJ	2.779	2.789		2.782	2.782	2.784	2.784	2.784
AK	0.240	0.260		R.250	R.250	0.250	0.250	0.250
AL	1.002	1.042		1.038	1.038	1.040	1.040	1.041
AM	0.053	0.073		R.063	R.063	0.063	0.063	0.063
AN	0.257	0.262		.257	.257	0.257	0.257	0.257
AO	1.663	1.683		1.675	1.675	1.676	1.675	1.673
AP	0.053	0.073		R.063	R.063	0.063	0.063	0.063
AQ	0.022	0.042		R.032	R.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: M. 34 9-89 / B = 19-11-30	Date: 2019/11/29
Audited by: gmm	Date: 12/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

335

DART AEROSPACE LTD		Work Order: 202850
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	7/2	8/3	9/4	10/5
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189		
AB	0.240	0.260		0.244	0.245	0.247		
AC	0.115	0.150		0.125	0.125	0.125		
AD	0.040	0.060		0.052	0.053	0.053		
AE	0.010	0.020		0.010	0.010	0.010		
AF	0.240	0.260		0.250	0.250	0.250		
AG	0.290	0.310		0.300	0.300	0.300		
AH	0.115	0.150		0.138	0.138	0.138		
AI	0.454	0.474		0.460	0.462	0.462		
AJ	2.779	2.789		2.784	2.784	2.784		
AK	0.240	0.260		0.250	0.250	0.250		
AL	1.002	1.042		1.038	1.036	1.040		
AM	0.053	0.073		0.063	0.063	0.063		
AN	0.257	0.262		0.257	0.257	0.257		
AO	1.663	1.683		1.672	1.675	1.674		
AP	0.053	0.073		0.063	0.063	0.063		
AQ	0.022	0.042		0.032	0.032	0.032		
AR								
AS								
AT								
Accept/Reject								

Measured by: D.C.	Date: 19-11-30
Audited by: J.M.C.	Date: 19/12/01
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	